Dart Aerospace Ltd. Tuesday, 11/29/2005 7:13:14 PM Date: Linda Lacelle User: **Process Sheet** : BLADE FITTING **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 25051 : 10020 **Estimate Number** : D27422 **Part Number** P.O. Number D2742 REV B **Drawing Number** : 11/29/2005 S.O. No. : This Issue : N/A Project Number Prsht Rev. : NC : B : MACHINED PARTS : 11 **Drawing Revision** √уре First Issue Material **Previous Run** Each 12 Um: Qty: : 12/26/2005 **Due Date** Written By **Checked & Approved By** : Created By Auto Work Order Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 7075-T651 3.25OD x 12.5L 1.0 D6103001 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: 7075-T651 3.25OD x 12.5L (D6103-001 BLANK) Batch :_ Tools: MORI SEIKI CNC LATHE LARGE 2.0 MORI SEIKI Comment: MORI SEIKI CNC LATHE LARGE TURN AS PER FOLIO FA099 & DSK050 FOLIO REV:___ DWG REV:_ Tools: INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE Tools: HAAS CNC VERTICAL MACHINING #1 HAAS1 4.0 Comment: HAAS CNC VERTICAL MACHINING #1 1-MACHINE AS PER FOLIO FA099 & DWG D2742 FOLIO REV:__ DWG REV:_____

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Tools:

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspector |
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| Part No: | PAR #: | Fault Category: | | NCR: Yes No DQA: | Date: | |
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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| ን* - | | Description of NC | .5 | . (| Corrective Action Section B | • | Verification | Annroyal | Anneval |
| DATE STEP Section A | | 4 | Initial Chief Eng | | | Section C | Approval Chief Eng | Approval QC Inspector | |
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NOTE: Date & initial all entries

1 6 Tuesday, 11/29/2005 7:13:14 PM Date: **Process Sheet** Linda Lacelle User: **Drawing Name:** BLADE FITTING Customer: CU-DAR001 Dart Helicopters Services Part Number: D27422 Job Number: 25051 Job Number: Description: **Machine Or Operation:** Seq. #: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE Tools: SECOND CHECK QC8 6.0 Comment: SECOND CHECK Tools: HAND FINISHING RESOURCE #1 HAND FINISHING1 7.0 Comment: HAND FINISHING RESOURCE #1 1-Chemical Conversion Coat as per QSI 005 4.1 2-Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3 Tools: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Tools: Insert ALS41032225 9.0 48.0000 Each(s) 4.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Batch Part Number Qty Insert ALS4-1032-225 AKS4-1032-225 ALS7-1032-225 AKS7-1032-225 Tools: HAND FINISHING RESOURCE #1 HAND FINISHING1 10.0 Comment: HAND FINISHING RESOURCE #1 Install ALS4-1032-225 Insert as per Dwg D2742 Tools:

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| Part No | : | | | PAR #: _ | ; | _ Fault Cate | gory: | | NC | R: Yes | No DQ | \: | Date: | |
| 444 | | • | • | | *************************************** | | | | | QA: I | N/C Close | d: | _ Date: _ | · |
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Date: User: Tuesday, 11/29/2005 7:13:14 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 25051

Part Number: D27422

Job Number:



Seq. #:

Machine Or Operation:

QC5

Description:

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

12.0

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL Inspection Level 21

Tools:

Job Completion



| Dart Aeros | pace | Ltd |
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| W/O: | | | WORK ORDER (| CHANGES | | | | |
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| DATE | STEP | PROC | CEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | \- | DAD # | Fault Category: | NCP: Voc | No DO | Δ. | Data | • |

QA: N/C Closed: ____

Date: ___

| NCR: | | | * | | | 1 | | | |
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| DATE | STEP | | Description of NC Section A | Initial Chief Eng | Corrective Action Section E Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Apprová QC Inspecto |
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| DART AEROSPACE LTD | Work Order: | |
|--|--------------|-------------|
| Description: Blade Fitting | Part Number: | D2742-2 |
| Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | Prototype |
|---|---------------|-----------|
|---|---------------|-----------|

| In Dra | spection Sheet wing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-----------|----------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| | 8.000 | +0.030/-0.000 | | | | | |
| | 9.250 | +/-0.010 | | | | | |
| | Ø3.240 | +0.005/-0.000 | | | | | |
| ш | Ø3.125 | +0.005/-0.000 | | | | | |
| LATHE | Ø2.780 | +0.005/-0.000 | | | | | |
| 7 | Ø2.450 | +0.005/-0.000 | | | | | |
| | 0.125 x 45° | +/-0.010 | | | | | |
| | 0.125 | +/-0.010 | | | | | |
| | 12.50 | +0.030/-0.000 | | | | | |
| | 0.100 x 0.135 | N/A | N/A | | | | |
| | 0.500 | +0.005/-0.000 | | | | | |
| | 1.500 | +/-0.005 | | | | | |
| | 11.46 | +/-0.030 | | | | | , |
| | 1.180 | +/-0.005 | | | | | |
| | 3.150 | +/-0.005 | | | | | |
| | 3.500 | +/-0.005 | | | | | |
| 6 | Ø0.484 | +0.005/-0.000 | | | | | |
| HAAS | Ø0.508 | +0.005/-0.000 | | | | | |
| I | 1.000 | +/-0.010 | | | | | |
| | 0.926 | +/-0.010 | | | | | |
| | 0.500 | +/-0.010 | | | | | |
| | 1.230 | +/-0.010 | | | | | |
| | 0.125 | +/-0.010 | | | | | |
| | 2.620 | +/-0.010 | | | | | |
| | 0.297 | +0.005/-0.000 | | | | | |
| | Ø0.430 x 0.045 | +/-0.010 | | | | | |

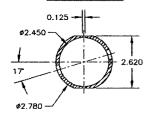
| Measured by: | Audited by: | Prototype Approval: | N/A |
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| Date: | Date: | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| Α | 03.12.12 | New Issue | KJ/RF | <u></u> |



Ø0.297 C'BORE Ø0.430 x 0.045" INSTALL ALS4−1032−225 (OR AKS4−1032−225 OR ALS7−1032−225 OR AKS7−1032−225) INSERTS AFTER FINISH (4 PLACES)

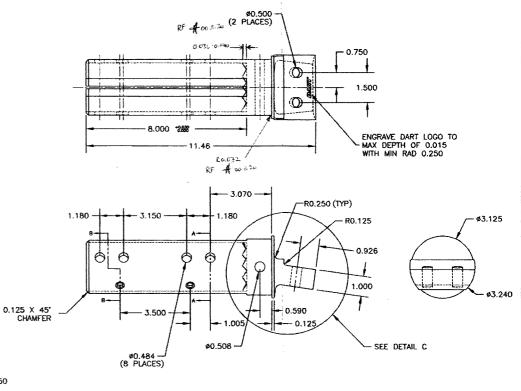
SECTION A-A

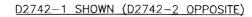


| EFFECTIVE | DEOs |
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GENERAL NOTES

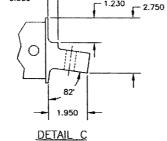
MATERIAL: 7075-T651 (QQ-A-200/11 OR QQ-A-225/9)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED SHAPP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







| В | 98.09.01 | ADD INSERTS, | AS MANUFACTURED |
|----------|----------|----------------------|--------------------------|
| Α | 98.04.16 | NEW ISSUE | |
| DESIGN | DRAWN BY | DART | DART AEROSPACE USA, INC. |
| CHECKED | APPROVED | DRAWING NO. D2742 | REV. B SHEET 1 OF 1 |
| DATE | | TMLE . | SCALE |
| 98.09.01 | | BLADE FITTING | 1:3 |



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RF \$ 81 00.5.20 400 50.092 + CHANGE EXE DETAIL